

Work Order ID 56868

March 11, 2010 11:20:35 AM



Page 1

Item ID: D3695-1

Revision ID:

Item Name: Slider

Start Date: 12/03/2010 Start Qty: 4.00

Required Date: 23/03/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3695

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 9.450" long

B.A 10/03/15

6 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA739 Rev: C & Dwg D3695 Rev: C 12-Deburr
per dwg D3695 13-Manually Tap for 10-32 heli coil

B.A 10/03/15

6 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 10/03/15

6 0

Work Order ID 56868

March 11, 2010 11:20:35 AM



Page 2

Item ID: D3695-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Slider

Start Date: 12/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 23/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

DJP 10/03/17

6 0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

M 10/03/18

X6 0

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

M 10/03/22

X6 0

Powder Coating

****mask threaded holes & un-hatched area as per dwg****

START TIME: 7:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:00AM

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Page 3

Item ID: D3695-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Slider

Start Date: 12/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 23/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M-L 10/03/23

(6X)

170

Identify as per dwg & Stock Location: 259

0.00



Packaging

Memo

0.00

Packaging

10/03/23 (6)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24 JF

M 10-3-23
(6)

Picklist Print

March 11, 2010 11:20:34 AM

Page 1

Work Order ID: 56868

Parent Item: D3695-1

Parent Item Name: Slider

Start Date: 12/03/2010

Required Date: 23/03/2010

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM IPP rev B
10.02.03 as per ncr 10-015 EC verified by: JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X0T.25 0		Purchased	No			100	f	27.5655	3.3617			



6061-T6 Bar 2.00 x T.25



2.5 x 1.5

For 10.03.15
Trip Batch only

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
MAT	27.56546842	
105838	6.9124	
110936	0.00036842	
113608	20.6527	
<u>107387</u>		

4.7500⁺⁺

B.A 10/03/15

DART AEROSPACE LTD		Work Order:	<u>56868</u>
Description: Slider		Part Number:	D3695-1
Inspection Dwg: D3695 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+0.000/-0.010	0.997	✓			
0.500	+/-0.010	0.496	✓			
0.300	+/-0.010	0.300	✓			
0.485	+0.000/-0.010	0.4835	✓			
2.000	+0.000/-0.010	1.995	✓			
8.750	+0.005/-0.000	8.752	✓			
Ø0.386	+0.006/-0.001	Ø0.389	✓			
Ø0.203	+0.005/-0.001	Ø0.207	✓			
0.738 deep	+/-0.010	0.738	✓			
0.500	+/-0.010	0.498	✓			
0.450	+/-0.010	0.450	✓			
2.025	+/-0.010	2.025	✓			
0.675 pitch	+/-0.010	0.675	✓			
1.075	+/-0.010	1.075	✓			
R0.25	+/-0.030	R0.250	✓			
0.13 x 45°	+/-0.030 x 0.5°	0.133 x 45°	✓			
0.900	+/-0.010	0.900	✓			
9.25	+/-0.030	9.250	✓			
0.50	+/-0.030	0.519	✓			
0.875	+/-0.010	0.874	✓			
0.310 deep	+/-0.010	0.310	✓			
4.75	+/-0.030	4.765	✓			
1.06	+/-0.030	1.054	✓			
1.000	+/-0.010	0.998	✓			

Measured by:	<u>BA</u>	Audited by:	<u>DJP</u>	Prototype Approval:	N/A
Date:	<u>10/03/15</u>	Date:	<u>10/03/17</u>	Date:	N/A

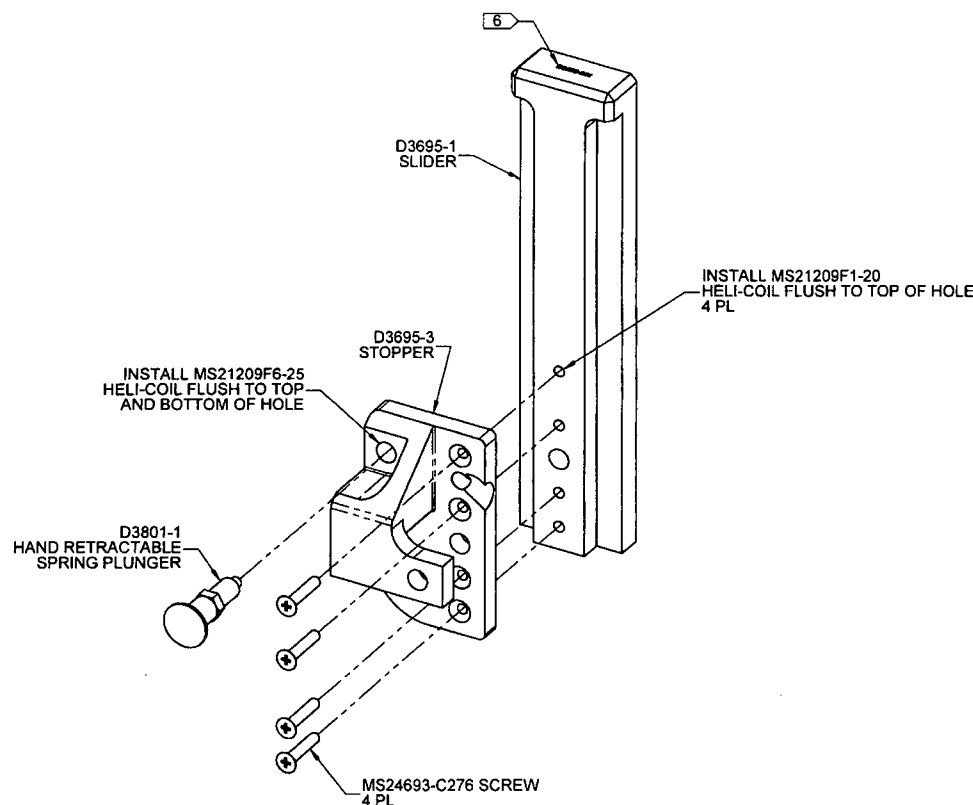
Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ <u>[Signature]</u>	<u>[Signature]</u>

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D3695-041	SLIDER ASSEMBLY
11	1	D3695-1	SLIDER
12	1	D3695-3	STOPPER
15	1	D3801-1	HAND RETRACTABLE SPRING PLUNGER
21	4	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
22	1	MS21209F6-25	HELI-COIL, SCREW LOCKING (RED)
23	4	MS24693-C276	SCREW

△

w/o 56868



D3695-041 SLIDER ASSEMBLY

RELEASED
9/24/25

C	UPDATED BOM TO CURRENT STANDARDS; REVISED ITEM 12 (ZN D3-1); DIMS 1.83 AND 1.075 ^{±.005} WERE 1.81 AND 1.063 ^{±.005} (ZN B8-3 AND C4-3). REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY.	MB	08.11.04
B	P/N D3808-1 WAS WMP-510 (ZN C7-1 AND D3-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN	LA		
DRAWN	LA		
CHECKED	LA		
MFG. APPR.	LA		
APPROVED	LA		
DE APPR.	LA		
DATE	08.11.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

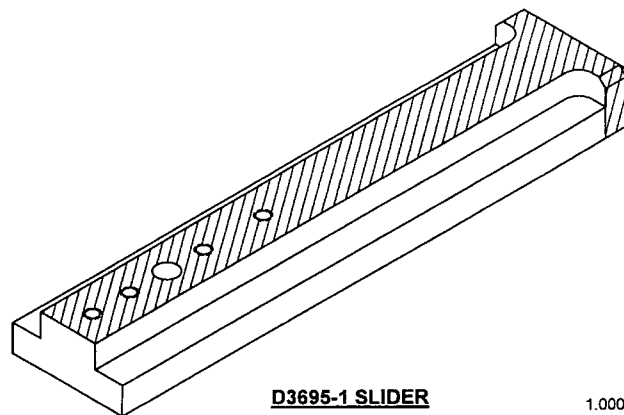
DRAWING NO. D3695
REV. C
SHEET 1 OF 3
TITLE SLIDER ASSEMBLY
SCALE NTS

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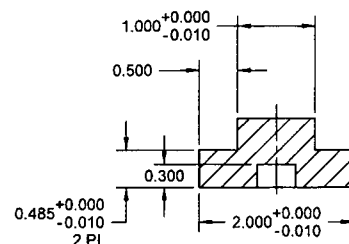
D3695-041 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3695-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: D3695-041 = 0.64 lbs

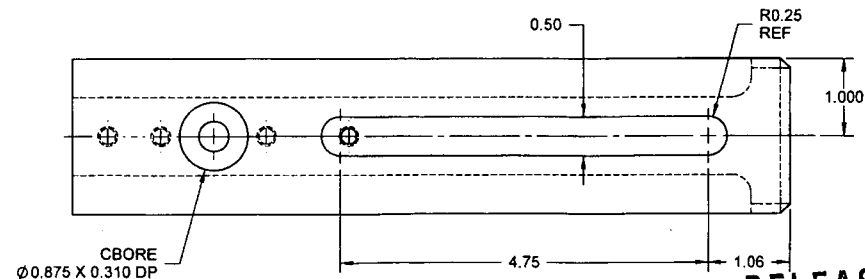
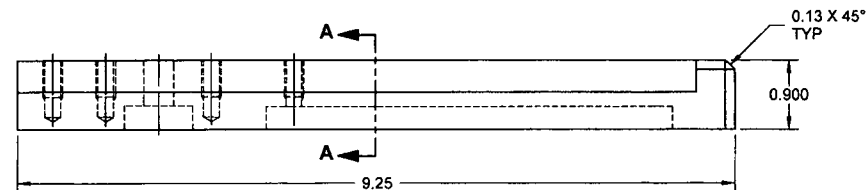
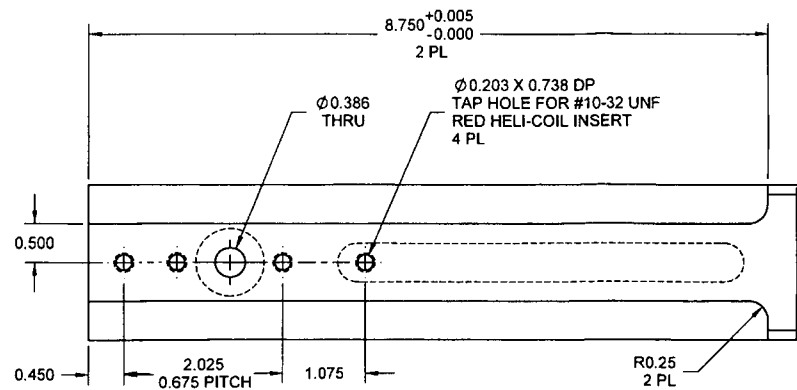
8 7 6 5 4 3 2 1



D3695-1 SLIDER



SECTION A-A

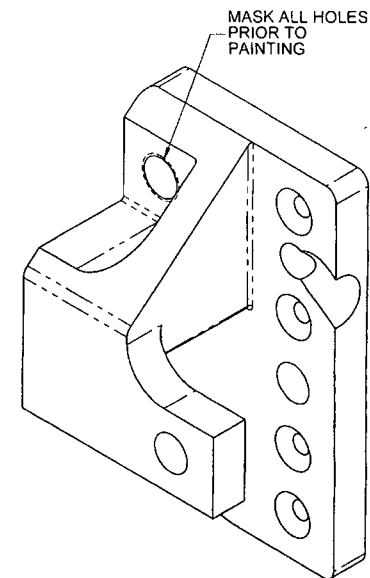
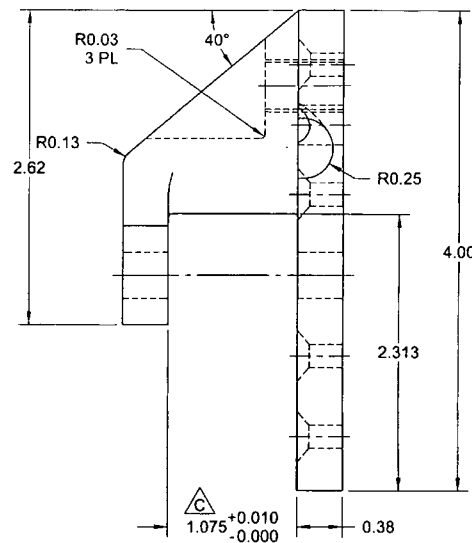
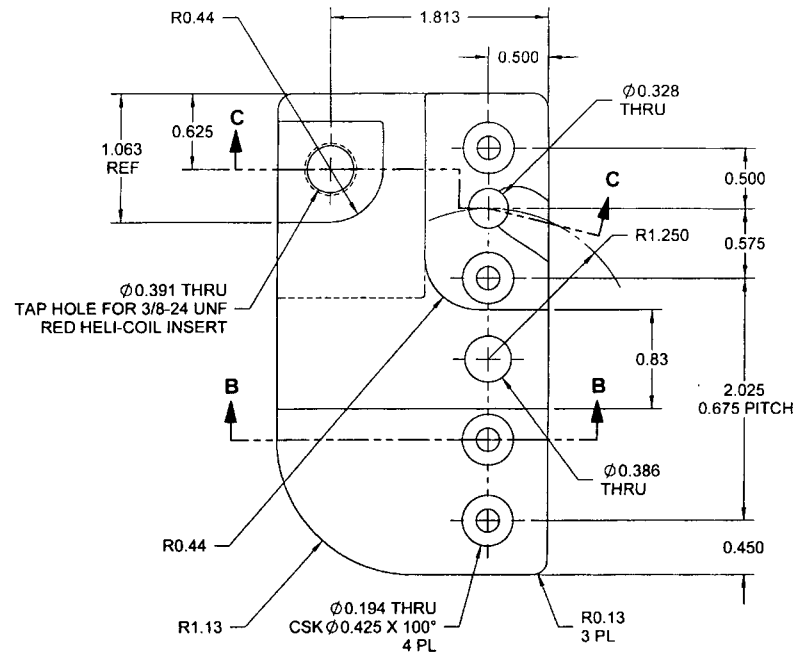


D3695-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDETEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

RELEASED
09/02/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3695	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
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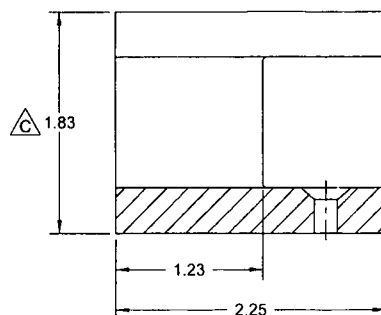


D3695-3 STOPPER

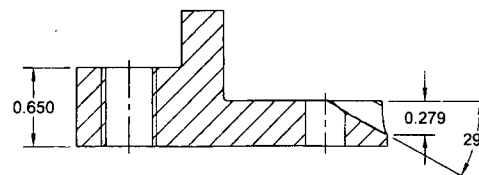
RELEASED
09/05/05

D3695-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs



SECTION B-B



SECTION C-C

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3695	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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